

**Work Order ID 69092**

Friday, April 29, 2011 8:54:07 AM

Page 1

Item ID: D3208-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Filler

Start Date: 4/29/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3208

Rev A1

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blank: 2.750" x 4.300" Identify for D3208-7

SAS 11/05/12

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Drill and Fillet D3208-7 corner as per Dwg D3208 Identify as D3208-7

SAS 11/05/12

120

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr D3208-7 Polish any marks on part within 01. of Dwg D3208

SAS 11/05/12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 69092**

Page 2

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Item ID: D3208-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Filler

Start Date: 4/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/1/05/02

(12)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

2 11/05/03

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2 BL 11-5-3



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**Work Order ID 69092**

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Page 3

Item ID: D3208-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Filler

Start Date: 4/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 202

0.00



Packaging

Memo

0.00

Packaging

11/3/3 SP (2)

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/4 SP

11/11-05-3 (2)



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# Picklist Print

Friday, April 29, 2011 8:54:14 AM

Page 1

Work Order ID: 69092

Parent Item: D3208-7

Parent Item Name: Filler



Start Date: 4/29/2011

Required Date: 5/3/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B04.05.25 Material changed for Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

83.5000

0.0902

0.189895



SB 11/05/02

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

83.5

112291

0.5

112331

19

113162

64

.200



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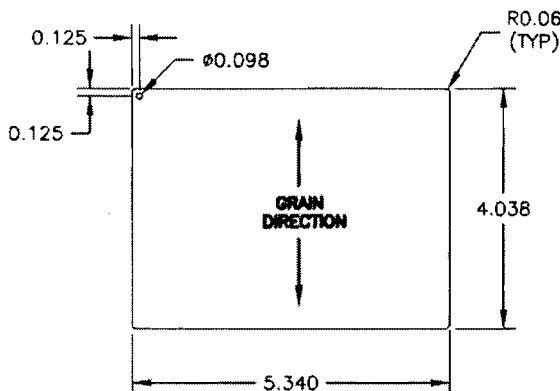
**NOTE:** Date & initial all entries



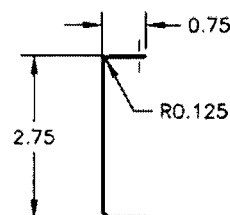


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	# 04.05.25	CHANGED DIM, NOTE 3) CHANGE	

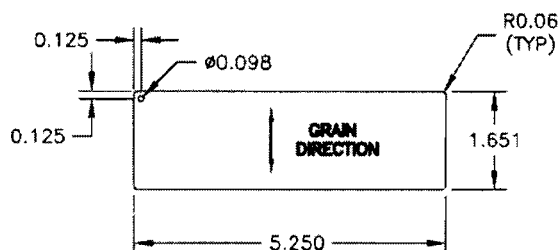
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04.04.05



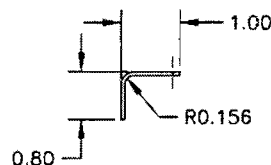
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



5) MATERIAL: 6061-T6 (QQ-A-250/4) 0.063" THICK (M6061T6.063)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69092

01/04-29

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**Dart Aerospace Ltd**

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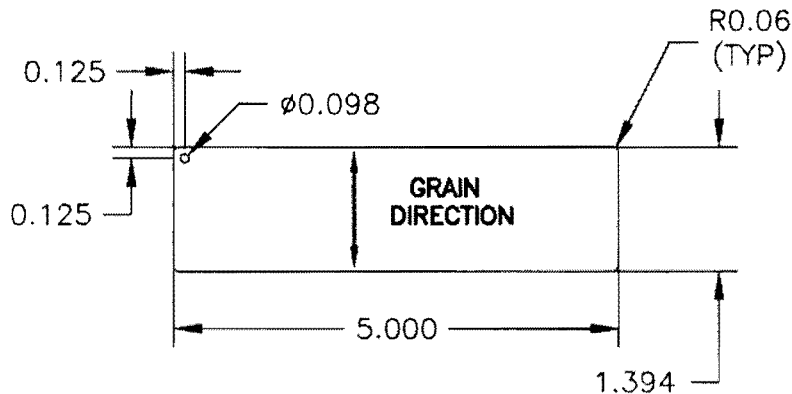
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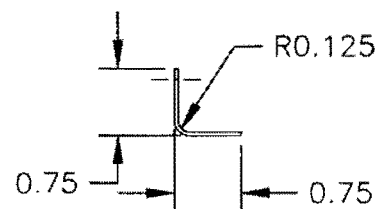


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DATE 04.01.27	TITLE DOUBLER		SCALE 1:2

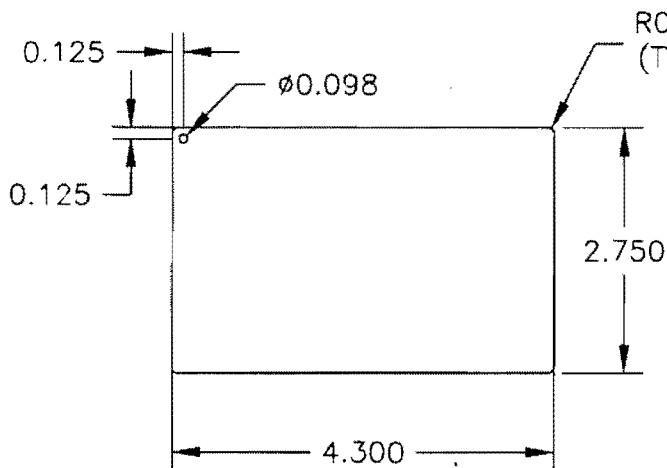
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04.04.05 #



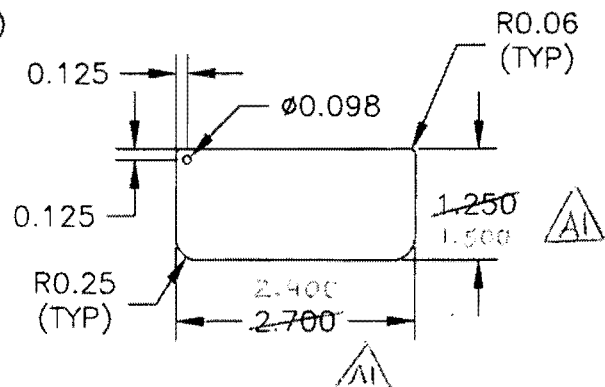
2 D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-5 MOUNT ANGLE  
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

W/069092

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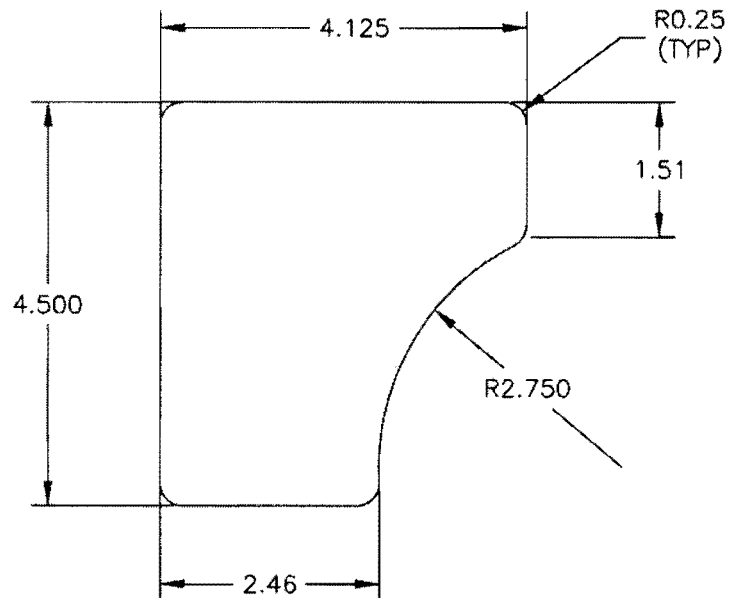
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED  
04.04.05



D3208-9 DOUBLER

w/o 69092

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# Dart Aerospace Ltd

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	/							

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